

Date: Friday, 9/29/2006 10:43:16 AM  
 User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: SPACER
Job Number	: 28791A	Part Number	: D2280
Estimate Number	: 10352	Drawing Number	: D2280 REV D
P.O. Number	: N/A	Project Number	: N/A
This Issue	: 9/29/2006	Drawing Revision	: D
Prsht Rev.	: NC	Material	: N/A
First Issue	: N/A	Due Date	: 10/10/2006
Previous Run	: 27756A	Qty:	40
Written By	: <i>[Signature]</i> 06/09/29	Um:	Each
Checked & Approved By	: <i>[Signature]</i>		
Comment	: Est Rev:A New Issue 05-11-07 JLM		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	M6061T6B0250X01000	6061-T6 Bar .25" x 1.0"	
		Comment: Qty.: 0.2975 f(s)/Unit Total : 11.8986 f(s) Material: 6061-T6 (QQ-A-250/8) 0.25" Thick (M6061T6B0.250x1.000) identify as D2280 Batch: M18237	<i>[Signature]</i> 06/10/03
2.0	SHEAR	SHEAR	
		Comment: SHEAR Cut blank: (3.400") +/-0.020"	<i>[Signature]</i> 06/10/03 40
3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1	
		Comment: HAAS CNC VERTICAL MACHINING #1	
		1-Machine per folio D2280 and Dwg D2280	
		2-Deburr Then Tumble	<i>[Signature]</i> 06/10/19 40
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE	<i>[Signature]</i> 06/10/19 40
5.0	QC8	SECOND CHECK	
		Comment: SECOND CHECK	<i>[Signature]</i> 06/10/20 x 40

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes  No  DQA:  Date: 06/10/24  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: SPACER

Job Number: 28791A

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Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

Y 06/10/20 x 40

7.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FL 06/10/23 (40)

8.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: SH 36

14/10/23 (40)

9.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

10/06/24

Job Completion



U 06/10/24.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	28791A
Description: Spacer	Part Number:	D2280
Inspection Dwg: D2280	Rev: D	Page 1 of 1

# FIRST ARTICLE INSPECTION CHECKLIST

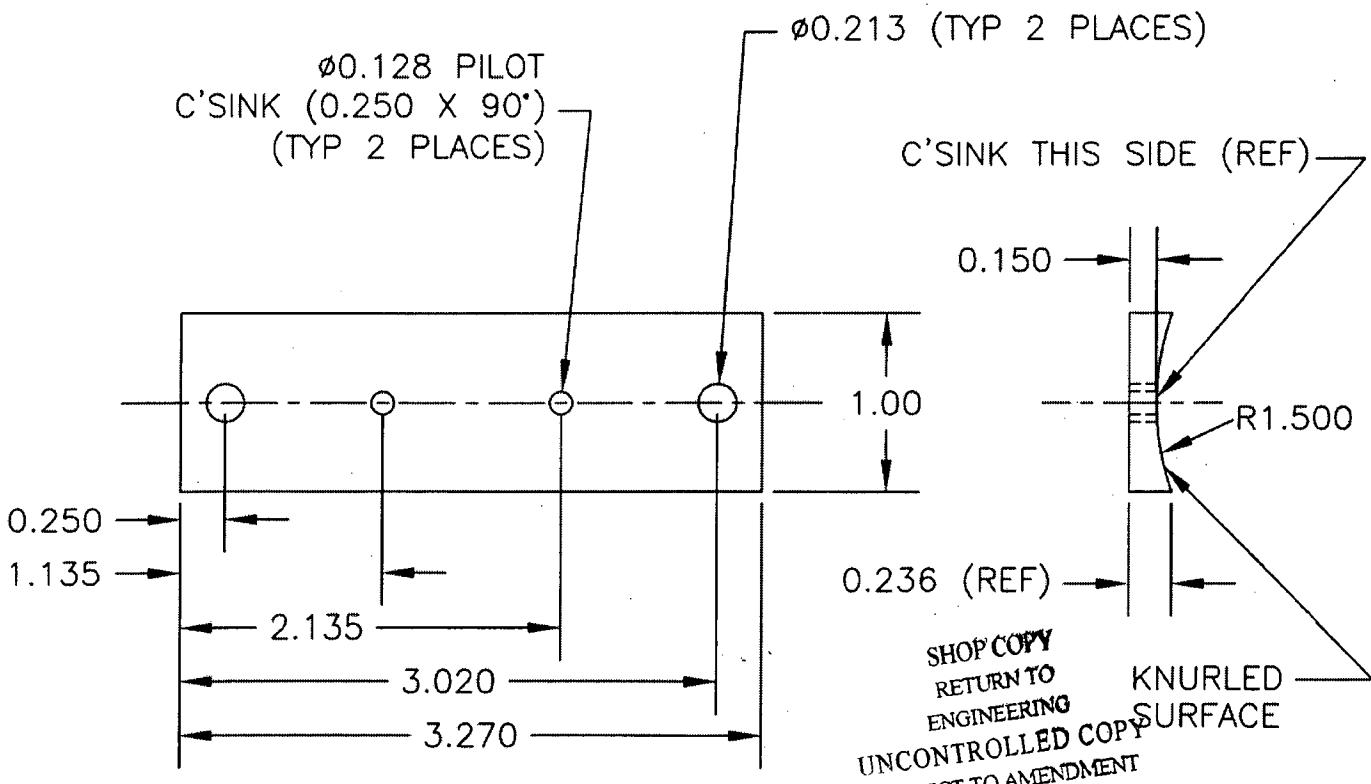
## X First Article      Prototype

Measured by:	J.F.	Audited by:	S.G.	Prototype Approval:	N/A
Date:	06/10/18	Date:	06/10/18	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.10.12	New Issue P/O D2582	KJ/JLM	
B	06.03.08	Dwg Rev changed	KJ/JLM	

**DART**

DESIGN <i>CH</i>	DRAWN BY <i>PB</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA
CHECKED <i>CH</i>	APPROVED <i>CH</i>	DRAWING NO. D2280 REV. D SHEET 1 OF 1
DATE 05.11.14	TITLE SPACER	SCALE 1:1
A	94.10.14	NEW ISSUE
B	95.03.22	MATERIAL CHANGE, 0.15 WAS 0.20
C	98.09.29	0.188 DIA HOLE CHANGED TO 0.213
D	05.11.14	ADD FINISHING NOTE

**RELEASED**  
*05.11.28 - CH*D2280 SPACER

- 1) MATERIAL: ALUMINUM 6061-T6 (QQ-A-200/8) BAR, 0.250 X 1.000 (REF. DART SPEC M6061T6B1.000X00.250)
- 2) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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